

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001537**Date Inspected:** 24-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 89M mock-up/Deck Panel**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Bay 1 - OGB Deck Panel (Gantry 1)

QA Inspector Brannon observed the Production Monitoring Test for the (SAW) process and for Production Deck Panels DP062-001, DP061-001 closed rib welds. ZPMC welding personnel performed machine gas metal arc (GMAW) for the root pass and submerged arc welding (SAW) for the cover pass. Dual process WPS-B-T-2342-U1(U-rib)-3 was posted as the welding procedure specification for closed rib welding. The following weld joint and welder were recorded for the PMT, DP062-001 and DP61-001 weld joint (wj) wj-#1 Mr. Han Chang Hou ID#059464, wj-#2 Mr. Chen Jie ID#059468, wj-#3 Mr. Gao Xin Dong ID#059361, wj-#4 Mr. Jiang Ting Guang ID#062255, wj-#5 Mr. Zhao Cheng Shuang ID#059400 and wj-#6 Mr. Yuan Feng Chuan ID#059355. Welding operator for the GMAW and SAW process was Mr. Li Xide. QA Inspector Brannon randomly observed ZPMC QC CWI Inspector Mr. Chen Xi monitoring welding parameters were in accordance with the Welding Procedure Specification (WPS).

Tower Shop**89 Meter Mock-Up**

QA Inspector Brannon observed ZPMC personnel are continuing with manual drilling of the bolt holes at skin plate E for the Shear Link Beam in a skewed position. QA Inspector also, observed ZPMC personnel removing weld metal by method of grinding, area's for the Shear Link Beams where the temporary stiffeners had been

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removed.

The following digital photographs below illustrates observation of the activities being performed.



Summary of Conversations:

No relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer
